

Work Order ID 86586

86586

Page 1

July-05-12 1:14:42 PM

Item ID: D2989-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Basket Lid Assembly

Start Date: 7/05/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: CY

Date: 12/07/05 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2989	Rev D

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs in DT9446 jig, weld as per dwg D2989
2- tack weld mesh on basket as per dwg D2989 using DT9446 jig
3- to locate hinges and shims use D2989-041, weld as per dwg D2989
A/R ER316 S.S. Rod Batch: M/22/30

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

PC/CC 12-8-23

1 φ 12-08-23

DAS
18
8-8-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

July-05-12 1:14:42 PM

Item ID: D2989-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Basket Lid Assembly

Start Date: 7/05/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 1.00 *1*

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

0.00

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Hand Finishing

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86586

86586

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July-05-12 1:14:42 PM

Item ID: D2989-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Basket Lid Assembly
Start Date: 7/05/12 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 8/03/12 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo 1- Plug holes prior to powder coating 2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989 1ST COAT START TIME: 2:00 OVEN TEMPERATURE: 480°F FINISH TIME: 2:30 ***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				1X			mf 12/08/23
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			12/08/24

W121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86586

86586

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July-05-12 1:14:42 PM

Item ID: D2989-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 7/05/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>D350-607</u>	0.00							
150		043	87537			1		20	12/08/27
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

CK 12/8/27
 MF
 12-08-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86586
Parent Item: D2989-043
Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12
Start Qty: 1.00

Required Date: 8/03/12
Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-041 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug holes prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2221-1 Rib		Manufactured	No			100	Each	8.0000	1	1		PL 12.8.2	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8						B82950 → ①	
				83907		8						PL 12.8.2	
✓ D2989-3 Rib		Manufactured	No			100	Each	5.0000	1	1		PL 12.8.2	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		4						B86715 → ①	
				77527		4							
				WA005		1							
				72408		1							
✓ D2989-4 Rib		Manufactured	No			100	Each	5.0000	1	1		PL 12.8.2	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		5						B86665 → ①	
				72409		1							
				77524		4							
✓ D2989-5 Rib		Manufactured	No			100	Each	4.0000	2	2		PL 12.8.2	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		3						B79463 → ①	
				81911		3						B86747 → ①	
				WA005		1							
				71222		1							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 86586
Parent Item: D2989-043
Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

✓ D3182-1 Hinge	Manufactured	No	100	Each	12.0000	2	2	<i>CPL 12.8.2</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	12				
			77316	4				
			82707	8				
✓ D3442-3 Shim	Manufactured	No	100	Each	14.0000	2	2	<i>CPL 12.8.2</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	14				
			79123	6				
			82708	8				
✓ D3827-041 Rib Assembly (Inboard)	Manufactured	No	100	Each	11.0000	1	1	<i>CPL 12.8.2</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	5				
			81038	5				
			WA006	6				
			72729	1				
			84792	5				
✓ D3832-5 Mesh (Lid)	Manufactured	No	100	Each	0.0000	1	1	<i>B 77756 → (1x) CC 12.8.23</i>
✓ D3833-5 Mesh (Lid End)	Manufactured	No	100	Each	38.0000	2	2	<i>B 67461 → (2x) CC 12.8.23</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA035	38				
			67461	38				
D3838-041 Rib Assembly (Basket Lid, LH)	Manufactured	No	100	Each	5.0000	1	1	<i>CC 12.8.22</i> <i>CPL 12.8.2</i>
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA005	5				
			77525	5				

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-05-12 1:14:41 PM

Page 3

Work Order ID: 86586

Parent Item: D2989-043

Parent Item Name: Basket Lid Assembly

Start Date: 7/05/12

Required Date: 8/03/12

Start Qty: 1.00

Required Qty: 1.00

D3838-042

Manufactured No

100

Each

5.0000

1

1

Rib Assembly (Basket Lid, RH)

Cx 1.2.8.2

Location

Loc Qty

Loc Code

WA005

5

72415

1

77526

4

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

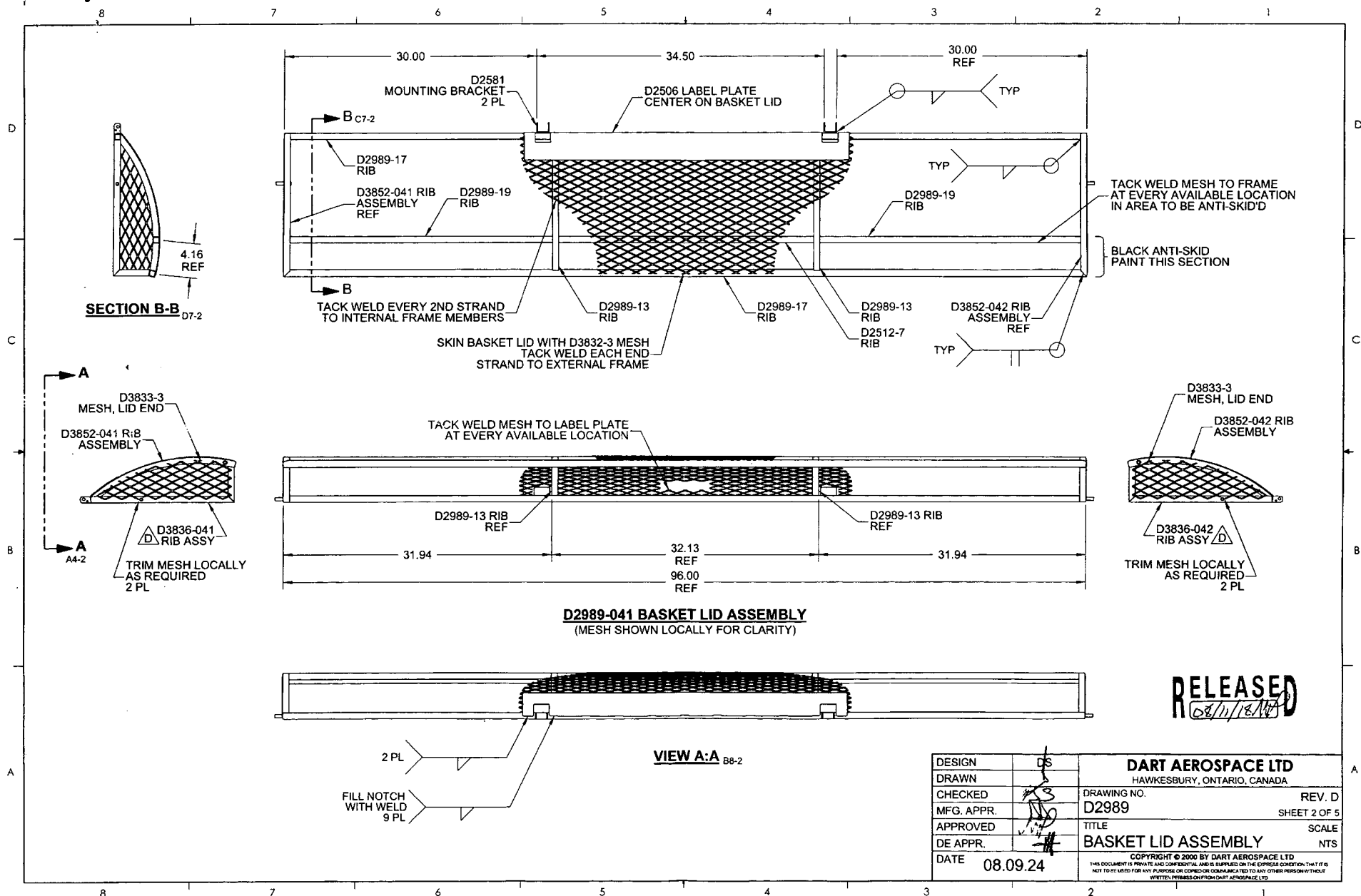
RELEASED
08/11/18

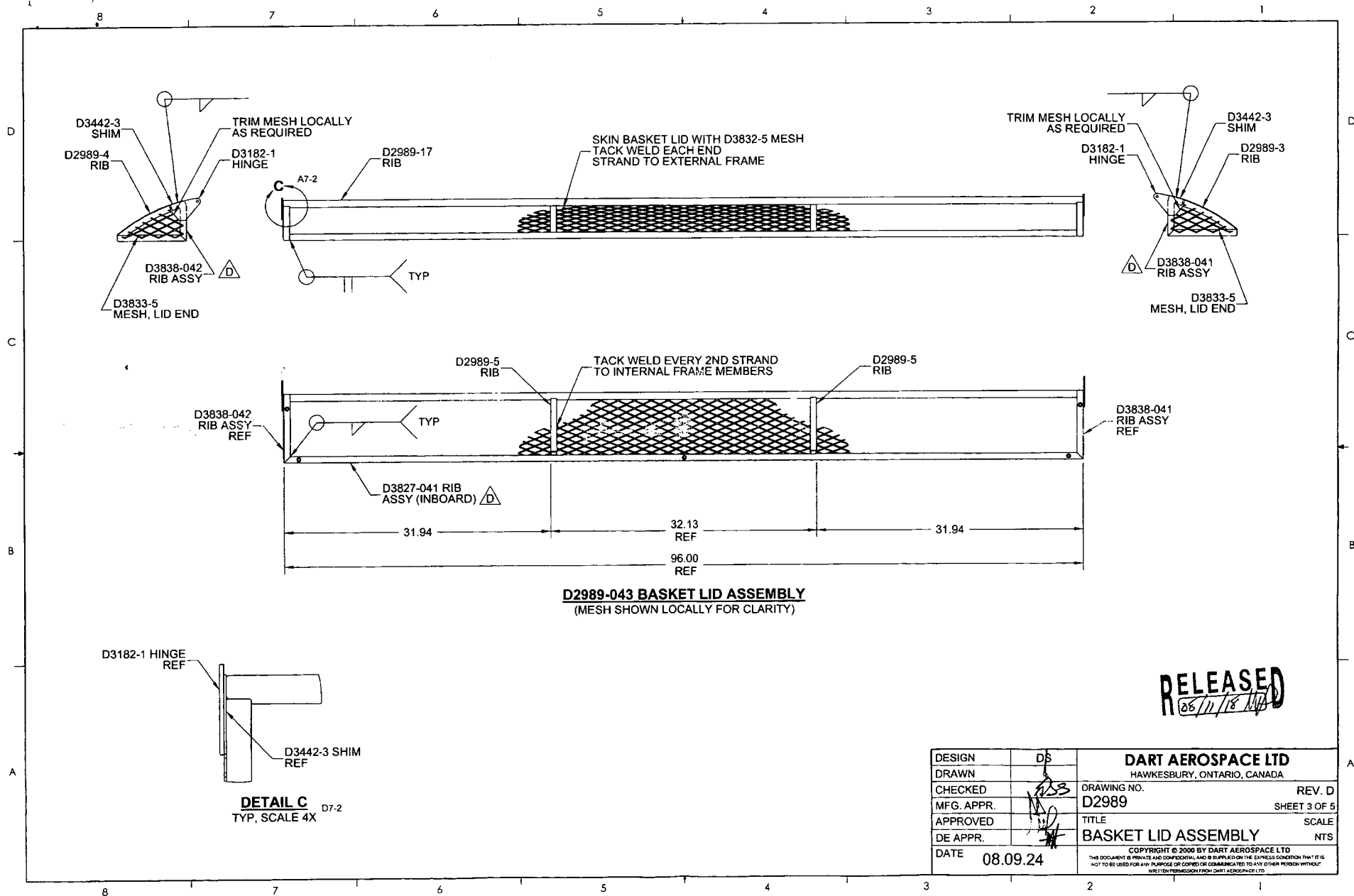
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-11/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG); D2989-9/-10 (NOW ON D3838 DWG); D2989-11/-12 (NOW ON D3852 DWG); REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. D
CHECKED		D2989	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID ASSEMBLY	NTS
DE APPR.		COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR IN ANY MANNER TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.24		

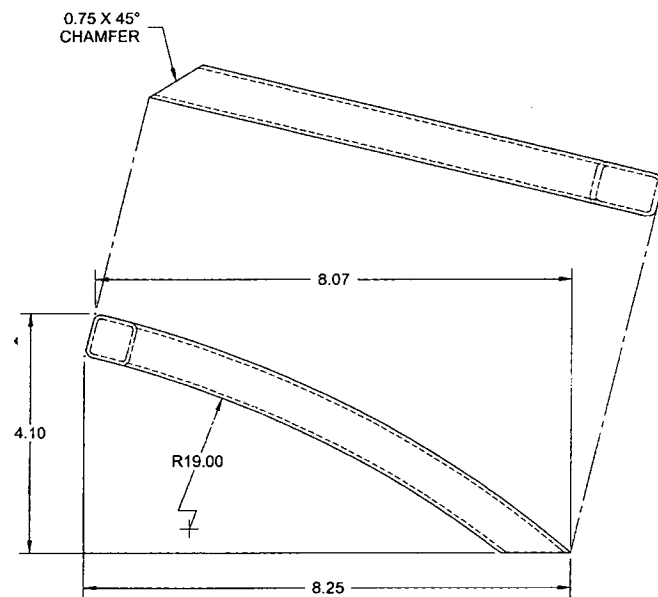
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
- 8) WELD PER DART QSI 004

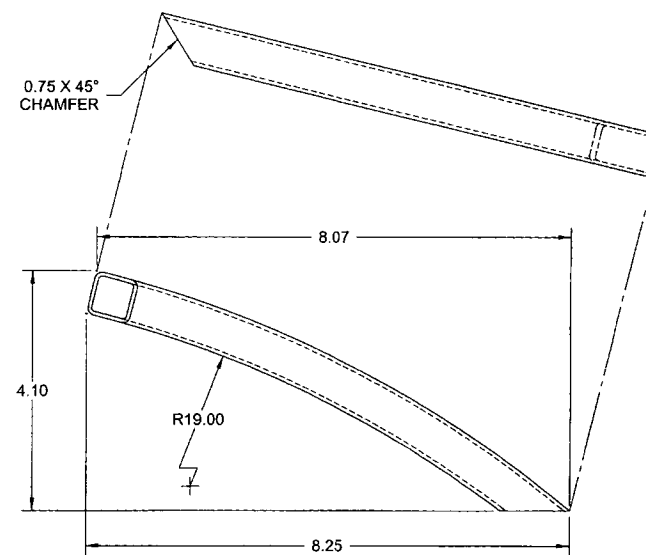
0812107105
W/O: 86586







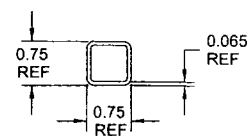
D2989-3 RIB



D2989-4 RIB

NOTES:

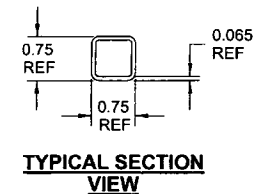
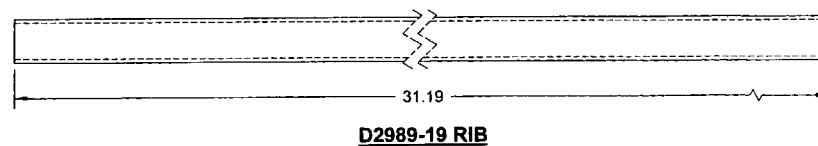
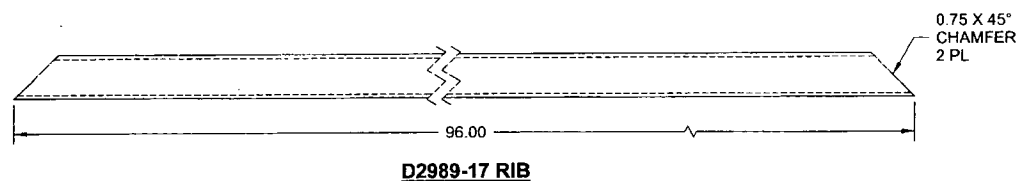
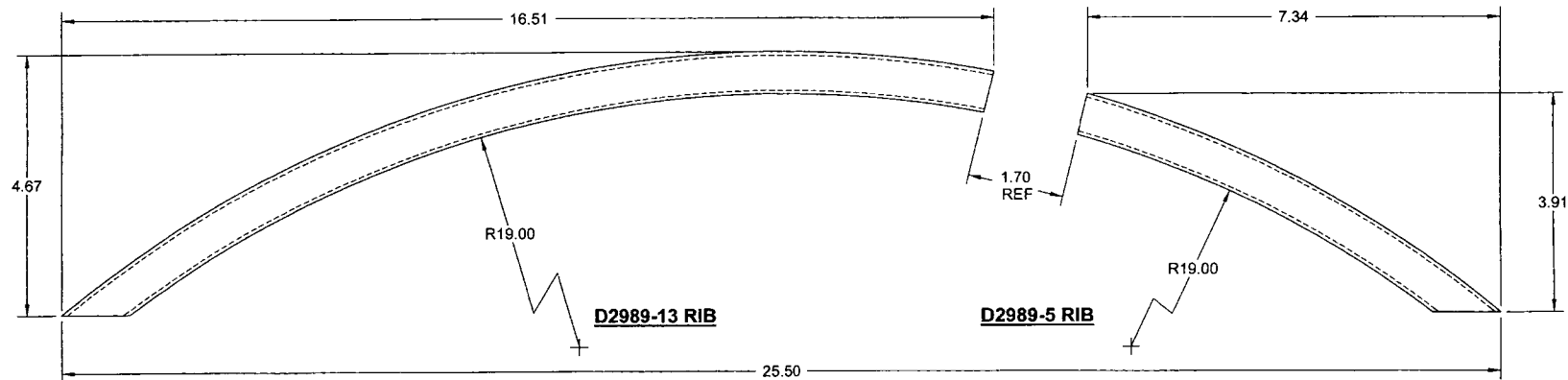
- 1) MATERIAL: D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18 NW

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2989	REV. D
MFG. APPR.			SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	OS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D2989	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY	NTS
DATE	08.09.24	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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08/11/18